



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-1027-153
Job Sheet 169676



Part No: D135-1027-153

Job Qty: 1 ea

Part Name: Mid Height Fwd Crosstube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 1/11/18

Created By: Diane Baker

Type: Stock

Description:

Note: TBD DWG REV A IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign off
					Setup hrs	Run Hrs	Workcenter / Supplier			
110	Purchasing	1 pcs	1/11/18	1/11/18	0.00	0.00	Purchasing	W		JAN 22 2018
120	Packaging	1 pcs	1/11/18	1/11/18	0.00	0.00	Packaging2	W		JAN 22 2018
130	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC15			18-02-24
140	Outsource	1 pcs	1/11/18	1/11/18	0.00	0.00	Outsource2			28/01/28
150	Packaging	1 pcs	1/11/18	1/11/18	0.00	0.00	Packaging2			18/01/28
160	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC5			38
170	Packaging	1 pcs	1/11/18	1/11/18	0.00	0.00	Packaging3-1			18/01/30
180	QC21-FG	1 Ea	1/11/18	1/11/18	0.00	0.00	QC21			18/01/30

Part Op 110 - Issue P/O to Tube Caron: 6038629 Manufacture D135-1027-153 as per dwg (Bend, Remove excess Descriptions: material after bending, Drill) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
120 - Ensure material release note is attached
140 - ISSUE P/O: 38854 C OF C IS REQUIRED
150 - C OF C IS REQUIRED

JAN 26 2018
DAS
13
9-29

DEC 19 2017

WLB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D135-1027-153P <u>5034185</u>	1	0	0	0
	D6025-120 <u>157904</u>	1	17	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S035808

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Mid Height Fwd Crosstube

PART NO: D135 - 1027 - 153

Original Serial #: S035808

Revision:

Operation:

Change No:

Purchasing

Mfg Date: 01/26/18

Job No: 169676



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038679

Items										
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	D135-1027-153P		Mid Height Fwd Crosstube As Per Dwg # D135-1027-153 Rev. B							
Line Item Note job# 169676 - Priority 1										
10	D135-1027-153P		Mid Height Fwd Crosstube As Per Dwg # D135-1027-153 Rev. B	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169664 - Priority 1										
11	D135-1027-153P		Mid Height Fwd Crosstube As Per Dwg # D135-1027-153 Rev. B	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169678 - Priority 1										
12	D135-1027-153P		Mid Height Fwd Crosstube As Per Dwg # D135-1027-153 Rev. B	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note Priority 1										
13	D135-1027-151P		Std Height Fwd Crosstube As Per Dwg D135-1027-151 Rev. C	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169665 - Priority 2										
14	D135-1027-151P		Std Height Fwd Crosstube As Per Dwg D135-1027-151 Rev. C	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169679 - Priority 2										
15	D135-1027-151P		Std Height Fwd Crosstube As Per Dwg D135-1027-151 Rev. C	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169680 - Priority 2										
16	D135-1027-151P		Std Height Fwd Crosstube As Per Dwg D135-1027-151 Rev. C	Firmed	1/12/18	1 pcs	0 pcs	1 pcs	\$600.00/pcs	\$600.00
Line Item Note job# 169681 - Priority 2										
									Grand Total: \$9,600.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



SHIPPING BILL

BOL 12425
16/01/2018

Tube Caron Inc.

99 Louis-Joseph-Doucet
Lanoraie, QC, Canada
J0K 1E0
Phone: 450-887-2766

Fax: 450-887-2897

Ship To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-1053

Fax : 613-632-4443

Sold To:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON, Canada
K6A 1K7
Phone : 613-632-5200

Fax : 613-632-4443

Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE	1			20.00	Pounds
	BOITE COMBO	1			13.00	Pounds
	D135-1027-153 REV B	2	P0038679	J17875-2	29.14	Pounds
	D135-1027-253 REV B	4	P0038679	J17875-1	79.24	Pounds

JAN 22 2018

Carrier:
Phone:
Way Bill:

Journey Freight
1-888-633-1252 #3221

Fob:
Freight Charges:

Fob Lanoraie
Collect

Total Of Packages :

1 SKID
48 X 40 X 91

Total Weight: 141.38 #

Carrier : Journey Freight

Shipper : Tube Caron Inc.

Audrey Tavan
Not Applicable For Insurance Purposes

Declared Value : (No Additional Insurance Required)

16-01-2018

DART AEROSPACE LTD		Work Order:	169676
Description: MID HEIGHT FWD CROSSTUBE		Part Number:	D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.550" TYP	+/-0.005"	3.55	✓		PD-10	
12.63" TYP	+/-0.030"	13.625	✓		tape	
2.14" REF	+/-0.030"	2.125	✓		PD-10	
2.75" TYP	+/-0.030"	2.75	✓		PD-10	
Ø.194" THUR 2PL	+0.006" -0.001"	.191"				
17.0" 2PL	+/-0.100"	17.063	✓		tape	
Ø.313" THUR 2PL	+0.006" -0.001"	.312"	✓		PD-10	
Ø.472" THUR 4PL	+0.006" -0.001"	.470"			PD-10	

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.134"	133	130	133	133				
21"	0.134"	133	132	133	134				
21"	0.134"	134	132	133	131				
CENTER OF BEND	0.134"	122	130	132	142				
CENTER OF BEND	0.134"	126	134	133	143				

OUTSIDE DIAMETER MEASUREMENTS

Location	DWG DIM	M1	M2				
CL	3.543"	3.547	3.547				
CENTER OF BEND	3.543"	3.556	3.506				
CENTER OF BEND	3.543"	3.553	3.508				

Crushing

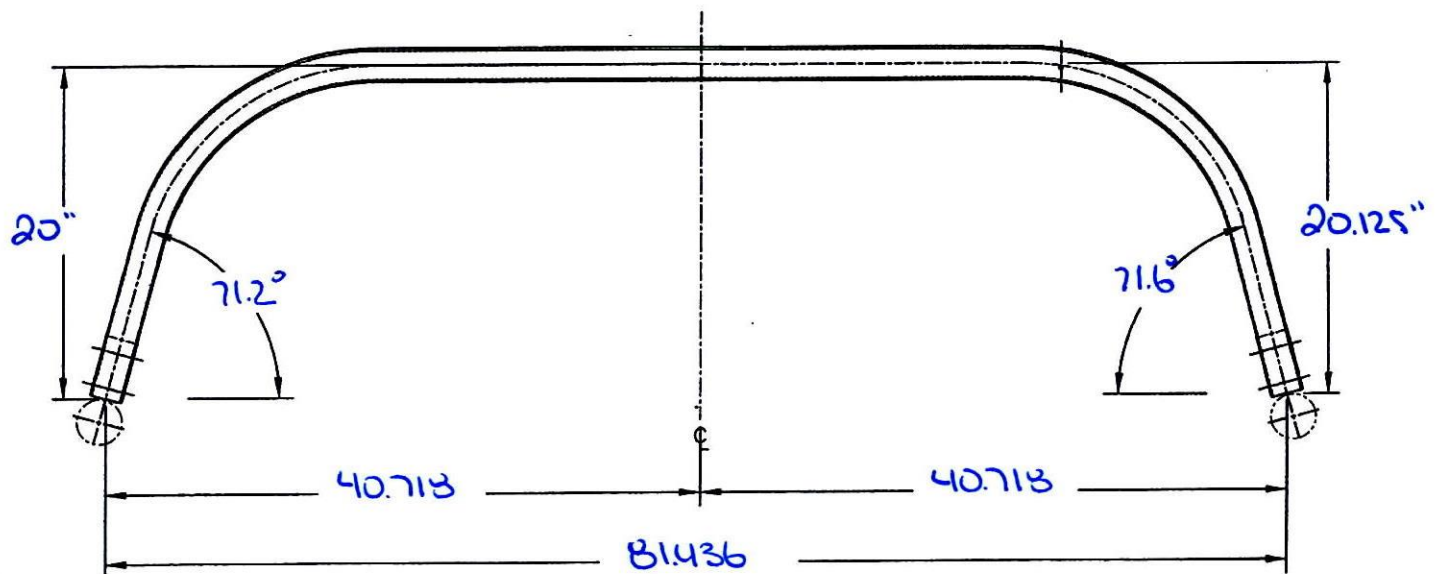
	Side A	Side B
MAX 2%	N/A	N/A

TWIST

	SIDE A	SIDE B
MAX 0.25"	N/A	N/A

DART AEROSPACE LTD		Work Order: 169676
Description: MID HEIGHT FWD CROSSTUBE		Part Number: D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 2 of 2

Required Dimension	Min	Max
Height	19.85"	20.11"
1/2 Span	40.60"	40.86"
Angle	70°	72°
Total Span	81.20"	81.72"
Bending Passes		
Crushing	0%	2%



Measured by: PD	Checked by:	QC Inspector:
Date: 18.01.24	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace

DATE : January 16, 2018

P.O.# PO038679

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 MID HEIGHT AFT XTUBE	4	D135-1027-253 / REV.B
D135-1027-153 MID HEIGHT FWD XTUBE	2	D135-1027-153 / REV.B

Note: 1) 2x D135-1027-153 were manufactured instead of the 4 requested on PO038679 due to the limited extrusions available. This information was communicated to Robert Aboud.

2) Center hole of Ø0.194" on one of the D135-1027-253 parts has a small defect that was accepted by Eric Downing.

Sincerely,



Michael Plante

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Date : <u>18/1/24</u>		Step #:		QTY Effective :			MRB (QSI042) Approval DAS 12 9-89 <u>18/1/24</u>																																																																												
Description Work Order Deviation				Disposition				Completed By																																																																											
ϕ 0.472 hole is ϕ 0.470 ϕ 0.194 hole is ϕ 0.191				ϕ 0.472 hole is acceptable. Open ϕ 0.191 holes to tolerance.				Lead hand / Supervisor Approval Verification <u>PD 18-0125</u> QC / QA Coordinator Approval <u>PD 18-0125</u>																																																																											
<table border="1" style="width:100%; border-collapse: collapse; font-size: x-small;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="6" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>☐ Environment</td> <td>☐ Design</td> <td>☐ Doc/Data</td> <td>☐ Equip/Tooling</td> <td>☐ Handling/Pre</td> <td>☐ Material</td> <td>☐ Internal Transport</td> <td>☐ Tribal Knowledge</td> <td>☐ LOA</td> <td>☐ Substation</td> <td>☐ Past Expiry Date</td> <td>☐ Misidentified</td> <td>☐ No Re-verification</td> <td>☐ Operator</td> <td>☐ Offset/Setup</td> <td>☐ Supplier</td> <td>☐ Training</td> <td>☐ Use for Testing</td> <td>☐ Poor Information</td> <td>☐ Rushing</td> <td>☐ Product Improvement</td> <td>☐ Process Improvement</td> <td>☐ Manufacturing Process</td> <td>☐ Past Due</td> <td>☐ Pressure/Forced</td> <td>☐ Bending</td> <td>☐ Centre Not Concentric</td> <td>☐ Cracks</td> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Cuffs</td> <td>☐ Crushing</td> <td>☐ Heat Treat</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Marks/Chatter</td> <td>☐ Temperature/Cure</td> <td>☐ Set-up</td> <td>☐ BOM/Route</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Contamination</td> <td>☐ Countersink</td> <td>☐ Cut Too Short</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Drill Holes</td> <td>☐ Power Loss/Surge</td> <td>☐ Folio/Program</td> <td>☐ Grain</td> <td>☐ Weld</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Out of Sequence</td> <td>☐ Off-set</td> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Misaligned/off center</td> <td>☐ Positioned Wrong</td> <td>☐ Outside Dimensions</td> <td>☐ Over/Under tolerance</td> <td>☐ Part Incorrect</td> <td>☐ Part Lost/Missing</td> <td>☐ Part Moved</td> <td>☐ Drawing</td> <td>☐ Finish</td> <td>☐ Misread</td> <td>☐ Turning Sequence</td> </tr> </tbody> </table>										Root Cause				FAULT CATEGORY						☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038854**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038854

PO Date: 1/25/18

Due Date: 1/26/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166582	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
2		D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
3		D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
4	170522	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14

1/26/2018

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	169676	D135-1027-153	Mid Height Fwd Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
6	169662	D135-1027-253	Mid Height Aft Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$156.14285/pcs	\$156.14
Grand Total:										\$936.86
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

DAS
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9-89

CY

Plex 1/26/18 10:44 AM dart.lavoie.chantal

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

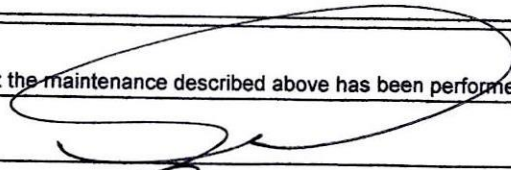
WO #: MWO34742	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038854
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

- 1 FWD CROSSTUB , P/N# D135-1027-153 , J/S# 169676
- 1 AFT CROSSTUBE , P/N# D135-1027-253 , J/S# 169662
- 2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 166582 , 166585
- 2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 170521 , 170522
- 1 UPPER END , P/N# SWA6A-100
- 1 LOWER END , P/N# SWA6A-200
- 1 BEARING HOUSING , P/N# SWA6A-300
- 2 SEMI RINGS , P/N# SWA6A-500
- 1 COLLAR , P/N# SWA6A-600

Action Taken:	Date:	Initial/Stamp:				
LPI AND MPI C/O IAW ASTM E-1417M-13 & E-1444M-12 DE-MAGNETIZED AS PER ASTM E-144494-A NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142 PARKER PROBE S/N 18163 , CAL. DUE 17/FEB/2018, CARRIER, MPO17874	JAN 25 2018	 				
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 25 2018
Name: RAFIK MELIKIAN		